

5/12

DART AEROSPACE LTD	Work Order:	22588
Description: Cross Bolt Spacer	Part Number:	D2649
Drawing: D2649 Rev. B1 RF 02/06/13	Qty:	737 1000

Step	Location	Procedure	By	Date	qty
1	EXPEDITING	Open W/O	HA	05.03.02	1000
2	CNC-CELL	Machine as per folio FA 215 on cobra machine. Material: 6061-T6 or 5052-H32, 0.375" Dia X 0.058" Wall Batch <u>15196</u> 17005	EP	05/04/23	737.
3	QC	Inspect Level 2	EP	05/04/23	737
4	QC	Inspect Level 8	2	05-04-27	737
5	STORES	Identify and stock	W	05-04-28	737
6	EXPEDITING	Close W/O Inspect level 21 Cost / part: .64 542 05/04/29 (737) 62	HA	05.05.03	737

Rev	Date	Change	Revised By	Approved
E	01.04.20	In-house process	EC	
F	02.03.26	Added turning on Cobra	NG	
G	02.04.04	Added inspect level 8	NG	02-04-05

RELEASED

02/04/04

80
31
11

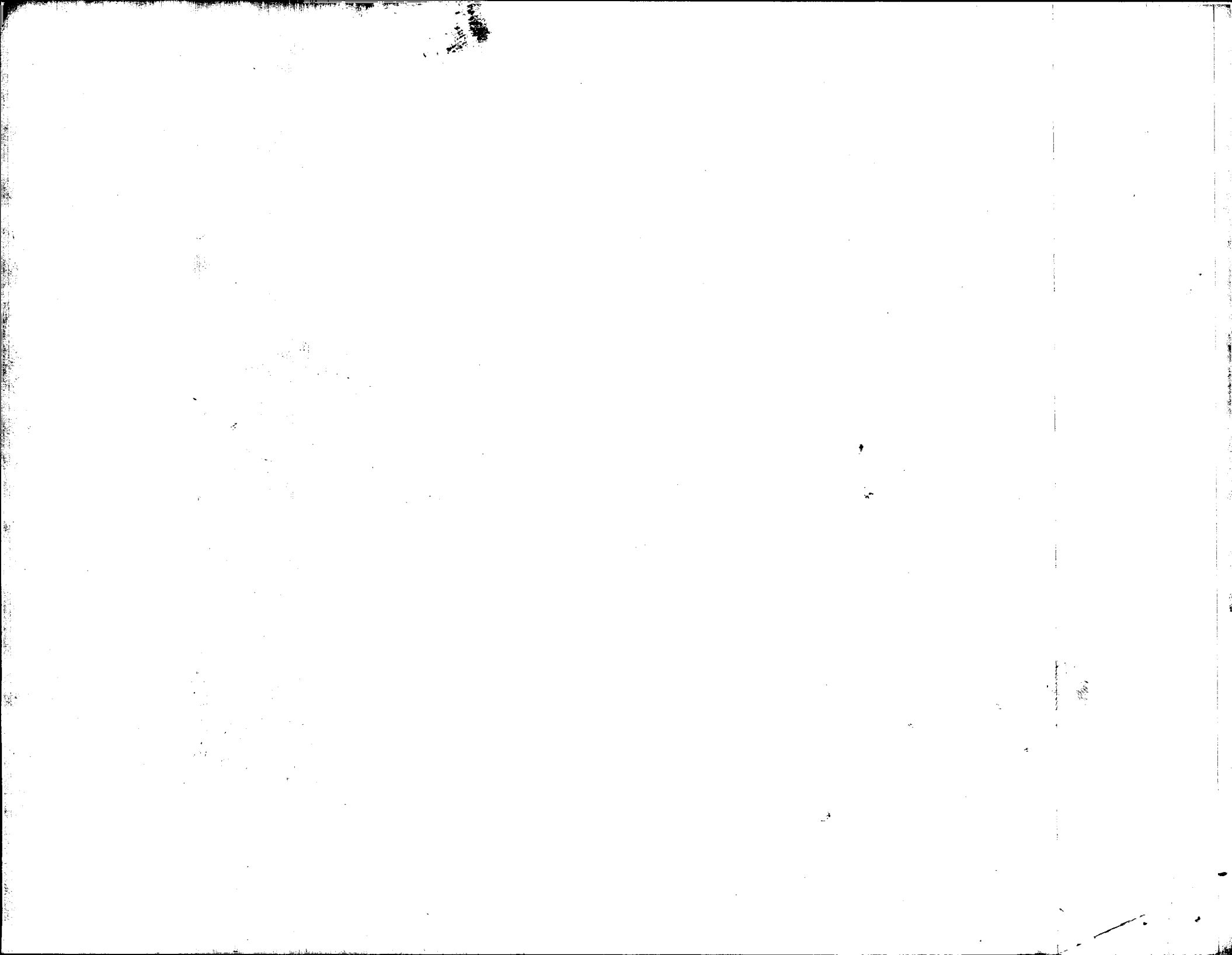
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

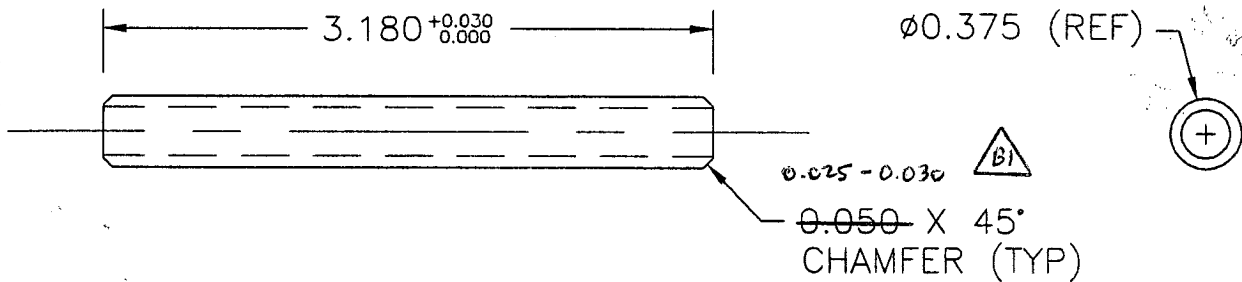
QA: N/C Closed: _____ Date: _____





DESIGN <i>DMS</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>DMS</i>	APPROVED <i>BW</i>	DRAWING NO. D2649	REV. B SHEET 1 OF 1
DATE 98.01.14		TITLE CROSS BOLT SPACER	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	98.01.14	3.180 WAS 3.230, ADD CHAMFER	
BI	CP 02.06.13	REDUCE CHAMFER PER TSR 1296.	

RELEASED
98.01.20 DS



UNLESS OTHERWISE NOTED
SUBMITTALS MUST BE
WITHOUT NOTICE

WORK ORDER
NO. 22588

MATERIAL: 6061-T6 (WW-T-700/6) OR 5052-H32 (WW-T-700/4)
0.375 DIA 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Mar 01, 2005
11:19 am

Work Order No	: 0022588	Department Code:	
Project Name	: D2649	Burden Flags	: NNNNNNNN
Project For	: WK512	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2649	Invoice Number	:
Description	: Crossbolt Spacer	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 1000	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	: 03-01-05	Actual Margin	: 0.000%
Est Finish Date	: 03-18-05		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
=====	=====	=====	=====	=====	=====
Material Cost	: 0.00	0.00	0.00	0.00	0.00
Engineering Hours	: 0.00	0.00	0.00		
Engineering Cost	: 0.00	0.00	0.00	0.00	0.00
Production Hours	: 0.00	0.00	0.00		
Production Cost	: 0.00	0.00	0.00	0.00	0.00
Packaging Hours	: 0.00	0.00	0.00		
Packaging Cost	: 0.00	0.00	0.00	0.00	0.00
OverHead Hours	: 0.00	0.00	0.00		
OverHead Cost	: 0.00	0.00	0.00	0.00	0.00
CNC Hours	: 0.00	0.00	0.00		
CNC	: 0.00	0.00	0.00	0.00	0.00
Misc. Hours	: 0.00	0.00	0.00		
Misc.	: 0.00	0.00	0.00	0.00	0.00
=====	=====	=====	=====		
Burden	: 0.00	0.00	0.00		
=====	=====	=====	=====		
Total Cost	: 0.00	0.00	0.00		
Margin	: 0.000	0.000			
Selling Cost	: 0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	: 0.00	0.00
Profits/(Loss)	: 0.00	0.00